

Work Order ID 122224

July-14-14 8:59:07 AM

122224

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Item ID: D2620 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube, 206 Skidtube
 Start Date: 7/14/14 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 7/14/14 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-07-14 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2620	Rev B								

100
 100
 Skidtubes
 Skidtubes
 Skidtubes
 Memo
 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
 206.A and Folio F008
 2- Cut Fwd end of tube as per Dwg D2620
 110
 110
 QC
 Quality Control
 Memo
 QC5- Inspect part completeness to step on W/O

[Handwritten signature] 14-7-14.
[Handwritten signature] 14-7-14
 DAS
 03
 9:59

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>L/G</u>	0.00				10	0	14-7-14	DGL
120	Packaging Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130	QC Memo	0.00							
Quality Control									

MLJ 1407-16

[Signature] 7-15

Picklist Print

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Work Order ID: 122224

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Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160		Manufactured	No			100	Each	99.0000	1	10			

D2600-1-160

Extrusion Round 3" 206

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	11	
103477	11	
LG	88	
115684	88	

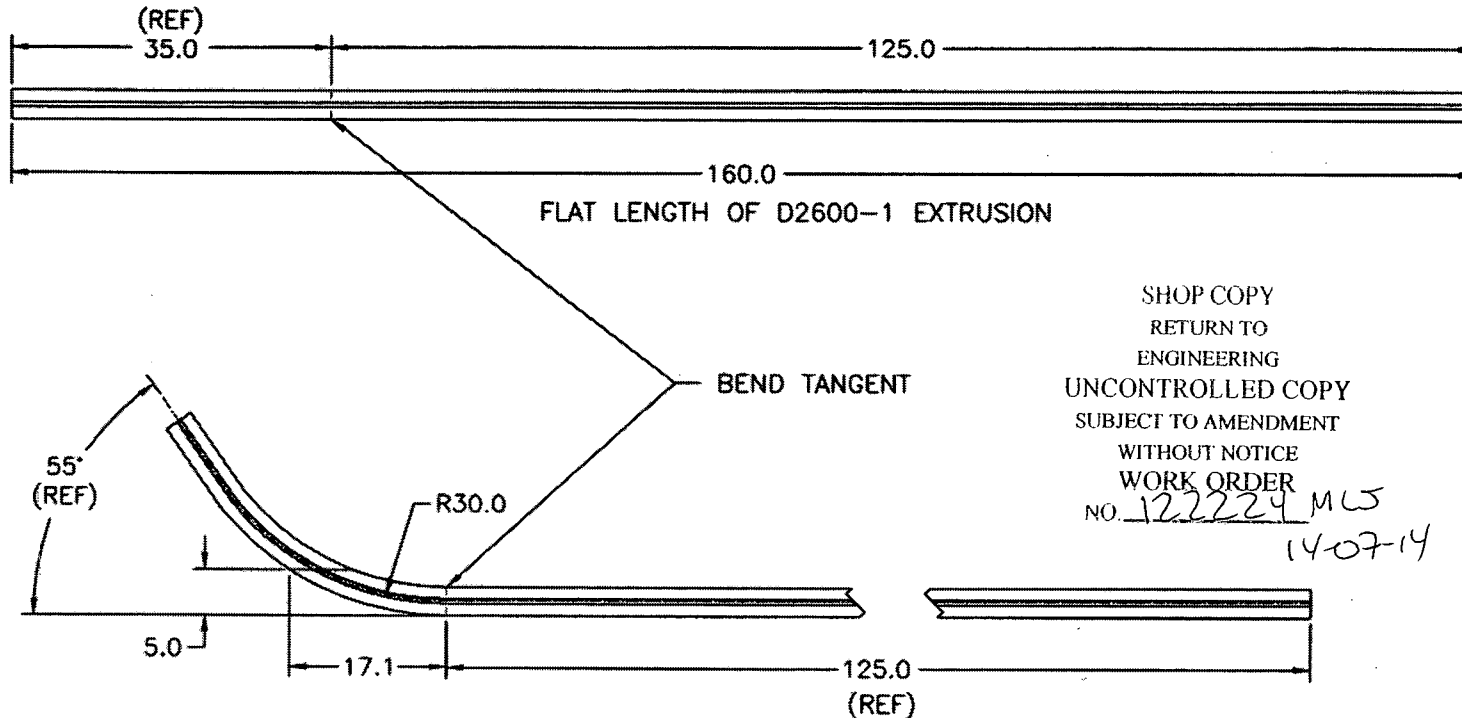
⑨
①

DC

14-7-14

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
99.04.15 DS

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA.
DATE	TITLE	REV. 8
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	SCALE
B	97.09.10	1:20
	NEW ISSUE	
	UPDATE FOR IN-HOUSE BENDING	